

Work Order ID 163339

Tuesday, June 27, 2017 12:08:59 PM

163339

Page 1

Item ID: D066-1001-013 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: R66 Bearpaws with Wearplates - Large
 Start Date: 7/4/2017 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 7/14/2017 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 9-89 Date: JUL 03 2017 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
IIN-D066-1001	REV B	<u>DAS 6 9-89</u> AUG 23 2017

100	Document Control	0.00				<u>2</u>	<u>DAS 28 9-89</u>	SEP 05 2017	
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPPD066-1001-013		CHG 003						

110	Pick Kit	0.00				<u>2</u>	<u>DAS 27 9-89</u>	AUG 24 2017	<u>rd</u>
110									
Packaging	Memo	0.00							
Packaging									

120	QC4- 100% Inspect kits for completeness	0.00				<u>2</u>	<u>DAS 28 9-89</u>	SEP 05 2017	
120									
QC	Memo	0.06							
Quality Control									

SEP 05 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition			Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER :									

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Revision ID:

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Start Date: 7/4/2017 Start Qty: 2.00 ***2***

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Required Date: 7/14/2017 Req'd Qty: 2.00 ***2***

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130	Packaging						DAS 28 9-89	SEP 0 5 2017	
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D066-1001-013 Location: _____ PPP Rev: _____ fg013								
140	QC21- Final Inspection - Work Order Release	0.00					DAS 21 9-89	SEP 0 5 2017	
140									
QC	Memo	0.20							
Quality Control							DAS 21 9-89	SEP 0 5 2017	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Work Order ID: 163339

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Parent Item: D066-1001-013

D066-1001-013

Parent Item Name: R66 Bearpaws with Wearplates - Large

Start Date: 7/4/2017

Required Date: 7/14/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 13-10-30 JLM VERIFIED BY:DD IPP
REV:B 13.12.03 AS PER IIN REV.B DD VERF:JLM IPP REV:C
15.04.08 AS PER CHG003 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3456-1

Manufactured No

110

Each

121.0000

4

8

D3456-1

**

Washer

Location

Loc Qty

Loc Code

FG

6

25701

6

ST036

115

159500

19

162291

96

AUG 24 2017

DAS
27
9-89

D3556-1

Manufactured No

110

Each

36.0000

4

8

D3556-1

**

R44 Bearpaw Clamp

Location

Loc Qty

Loc Code

ST542

36

152480

16

162033

20

AUG 24 2017

DAS
27
9-89

D3601-1

Manufactured No

110

Each

59.0000

8

16

D3601-1

**

Radius Block

Location

Loc Qty

Loc Code

ST045

59

156511

59

AUG 24 2017

DAS
27
9-89

DAS
28
9-89

DAS
28
9-89

DAS
28
9-89

165522

164111x10

WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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Parent Item: D066-1001-013

D066-1001-013

Parent Item Name: R66 Bearpaws with Wearplates - Large

Start Date: 7/4/2017

Required Date: 7/14/2017

Start Qty: 2.00

Required Qty: 2.00

D4930-3 Manufactured No

110 Each

1.0000 2 4

D4930-3

Bearpaw

DAS
28
9-89

Location

Loc Qty

Loc Code

ST454a

1

B162351

4

112356

1

D4952-041

Manufactured No

110 Each

15.0000 4 8

D4952-041

Wearplate Assembly

DAS
28
9-89

Location

Loc Qty

Loc Code

ST188

15

158902

7

160568

8

D4953-1

Manufactured No

110 Each

108.0000 4 8

D4953-1

Cushion

DAS
28
9-89

Location

Loc Qty

Loc Code

st543

108

153229

108

AN4-12A

Purchased No

110 Each

100.0000 4 8

AN4-12A

Bolt

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

10

120423

10

ST344

90

m137412

90

AUG 24 2017

DAS
27
9-89

AUG 24 2017

DAS
27
9-89

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DAS
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9-89

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D066-1001-013

Parent Item Name: R66 Bearpaws with Wearplates - Large

Start Date: 7/4/2017

Required Date: 7/14/2017

Start Qty: 2.00

Required Qty: 2.00

AN4-15A Purchased No

110 Each 174.0000 4 8

AN4-15A

Bolt

**

AUG 24 2017

DAS 27 9-89

DAS 28 9-89

Location

Loc Qty

Loc Code

GA

10

M138040

8

120449

10

over003

100

m137820

100

ST343

64

m137587

64

AN4-16A Purchased No

110 Each 195.0000 4 8

AN4-16A

Bolt

**

AUG 24 2017

DAS 27 9-89

DAS 28 9-89

Location

Loc Qty

Loc Code

FG

5

M138209

8

121541

5

ST343

190

M137507

190

NAS1149D0463J Purchased No

110 Each 3,565.000 8 16

NAS1149D0463.I

Washer

**

AUG 24 2017

DAS 27 9-89

DAS 28 9-89

Location

Loc Qty

Loc Code

GA

40

M138084

16

M135056

40

ST260a

2000

M137699

2000

ST263

1525

M137371

1525

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Shop Packet Print

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WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____		Work Order update only ☐																																																																
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Picklist Print

Tuesday, June 27, 2017 12:08:57 PM

Page 4

Work Order ID: 163339

163339

Parent Item: D066-1001-013

D066-1001-013

Parent Item Name: R66 Bearpaws with Wearplates - Large

Start Date: 7/4/2017

Required Date: 7/14/2017

Start Qty: 2.00

Required Qty: 2.00

MS21042L4

Purchased

No

110

Each

2,061.000

12

24

MS21042L4

Nut

**

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

10

m133363

10

GA

51

m135058

51

OVER007

1400

m137402

400

m137680

1000

ST303

600

m137544

600

1137788

24

AUG 24 2017

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____		Work Order update only ☐																																																																																									
Work Order: _____ Part No. _____ NCR No. _____		<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <th colspan="2" style="text-align: center;">DISPOSITION</th> <th colspan="4" style="text-align: center;">AGAINST DEPARTMENT/PROCESS</th> </tr> <tr> <td style="text-align: center;">Rework ☐</td> <td style="text-align: center;">Skid-tube ☐</td> <td style="text-align: center;">Cross tube ☐</td> <td style="text-align: center;">Water Jet ☐</td> <td style="text-align: center;">Engineering ☐</td> <td></td> </tr> <tr> <td style="text-align: center;">Scrap ☐</td> <td style="text-align: center;">Machining ☐</td> <td style="text-align: center;">Small Fab ☐</td> <td style="text-align: center;">Prod. Eng. Coord. ☐</td> <td style="text-align: center;">Quality ☐</td> <td></td> </tr> <tr> <td style="text-align: center;">Use-as-is ☐</td> <td style="text-align: center;">Thermoforming ☐</td> <td style="text-align: center;">Finishing ☐</td> <td style="text-align: center;">Rec/Store/Packaging ☐</td> <td style="text-align: center;">Other ☐</td> <td></td> </tr> <tr> <td style="text-align: center;">Suspected Unapproved ☐</td> <td style="text-align: center;">Large Fab ☐</td> <td style="text-align: center;">Composite ☐</td> <td style="text-align: center;">Supplier ☐</td> <td></td> <td></td> </tr> </table>		DISPOSITION		AGAINST DEPARTMENT/PROCESS				Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																												
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Tuesday, June 27, 2017 12:08:59 PM

Item ID: D066-1001-013

Accept

N900040100

Setup Start *NS1*

Revision ID:

NS1

Item Name: R66 Bearpaws with Wearplates - Large

Stop *NS2*

Start Date: 7/4/2017 **Start Qty:** 2.00

2

Cust Item ID:

Required Date: 7/14/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** JUL 03 2017 **Tooling:** _____ **Date:** _____
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run **Start** ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	AUG 23 2017
IIN-D066-1001	REV B	

100	Document Control	0.00
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100 DOCUMENT CONTROL
 DC Memo 0.00

Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPPD066-1001-013	CHG 003
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110	Pick Kit	0.00
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110			
Packaging	Memo	0.00	

Category	Item	Quantity	Unit Price	Total Price
Packaging	Box	100	0.50	50.00
	Label	1000	0.05	50.00
Material	Steel	1000	0.10	100.00
	Aluminum	1000	0.15	150.00
Labor	Assembly	1000	0.20	200.00
	Finishing	1000	0.10	100.00
Transportation	Truck	1000	0.05	50.00
	Trailer	1000	0.05	50.00
Insurance	Life	1000	0.05	50.00
	Health	1000	0.05	50.00
Maintenance	Oil	1000	0.05	50.00
	Filter	1000	0.05	50.00
Repairs	Parts	1000	0.05	50.00
	Labor	1000	0.05	50.00
Storage	Warehouse	1000	0.05	50.00
	Truck	1000	0.05	50.00
Distribution	Truck	1000	0.05	50.00
	Trailer	1000	0.05	50.00
Sales	Truck	1000	0.05	50.00
	Trailer	1000	0.05	50.00
Marketing	Truck	1000	0.05	50.00
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	Trailer	1000	0.05	50.00
Sales	Truck	1000	0.05	50.00

120	QC4- 100% Inspect kits for completeness	0.00
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120
QC Memo 0.06

Quality Control

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D066-1001-011	8.3 lb	0.0 in	0.0 in-lb	123.89 in	1028 in-lb
<i>Bearpaw Installation (Small)</i>	3.74 kg	0.0 m	0.0 m-kg	3.14 m	11.7 m-kg
D066-1001-013	9.8 lb	0.0 in	0.0 in-lb	124.98 in	1225 in-lb
<i>Bearpaw Installation (Large)</i>	4.41 kg	0.0 m	0.0 m-kg	3.17 m	14.0 m-kg

5.0 PARTS LIST

Qty -011	Qty -013	Part Number	Description
X		D066-1001-011	BEARPAW INSTALLATION (SMALL)
	X	D066-1001-013	BEARPAW INSTALLATION (LARGE)
4	4	D3456-1	Washer
4	4	D3556-1	Clamp
8	8	D3601-1	Radius Block
2		D4930-1	Bearpaw
	2	D4930-3	Bearpaw
4	4	D4952-041	Wearplate
4	4	D4953-1	Cushion
4	4	AN4-12A	Bolt
4	4	AN4-15A	Bolt
4	4	AN4-16A	Bolt
8	8	NAS1149D0463J	Washer
12	12	MS21042L4	Nut (or MS21042-4)